

Work Order ID 158104

Thursday, March 09, 2017 2:18:57 PM

158104

Page 1

Item ID: D2153 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Prop

Start Date: 3/13/2017 Start Qty: 36.00 ***36*** Cust Item ID:
Required Date: 3/27/2017 Req'd Qty: 36.00 ***36*** Customer:

Reference: SCHEDULED

Approvals: Process Plan: **DAS 21 9-89** Date: **MAR 10 2017** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2153	Rev A1								DAS 13 9-89
100		0.00							
100	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>35614</u> Gas Spring P/N: SL13-10 (10lb) Possible supplier: Spring Lift Corporation**Note: Do not ship by air****Allow an extra 7 to 10 business days for shipping**Material release note is required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.12							
Packaging	Ensure Material Release Note is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Inspect Test Spring is 10lb								

36x SP17-45**(36)****DAS 38 9-89
APR 06 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00							
	Memo	0.21				36x			DAS 36 9-89 17/04/06
	1- Assemble as per Dwg D21532- Remove Spring Lift name and address with Acetone, leave only warning: "DO NOT OPEN HIGH PRESSURE"								
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.12							DAS 38 9-89 17-04-06
	Quality Control								
150 *150* Packaging	Identify as per dwg & Stock Location: <u>ST362</u>	0.00							
	Memo	0.06							DAS 41 9-89 APR 08 2017
	Packaging					36			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Page 3

Item ID: D2153

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Prop

Start Date: 3/13/2017 Start Qty: 36.00

36

Cust Item ID:

Required Date: 3/27/2017 Req'd Qty: 36.00

36

Customer:

Reference: SCHEDULED

Run Start ***NR1***

Approvals: Process Plan: Date:

Tooling: Date:

Stop ***NR2***

QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.06

Quality Control

17/4/11 DAS
21
9-89
APR 10 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Thursday, March 09, 2017 2:19:12 PM

Page 1

Work Order ID: 158104

158104

Parent Item: D2153

D2153

Parent Item Name: Door Prop

Start Date: 3/13/2017

Required Date: 3/27/2017

Start Qty: 36.00

Required Qty: 36.00

Comments: IPP: E 02.07.08 Re-format KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
SL69-BS *SI 69-RS* Ball Stud		Purchased	No			100	Each	55.0000	2	72			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		55							
					M135261	55				50			
D2153P *D2153P* Door Prop		Purchased	No			130	Each	0.0000	1	36			
D3015-3 *D3015-3* Locknut		Manufactured	No			130	Each	73.0000	2	72			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		18							
					95758	8							
					96151	10							
				ST015		55							
					154891	55				22			
NAS1149D0563J *NAS1149D0563.I* Washer		Purchased	No			130	Each	1,124.000	2	72			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		187							
					m135774	187				72			
				ST263		937							
					m136295	237							
					m136986	700							

17/04/06 DAS 36 9-89
137196
22x
17/04/06 DAS 36 9-89
17/04/06 DAS 36 9-89
50x
158189
17/04/06 DAS 36 9-89

DQA: _____ Date: _____



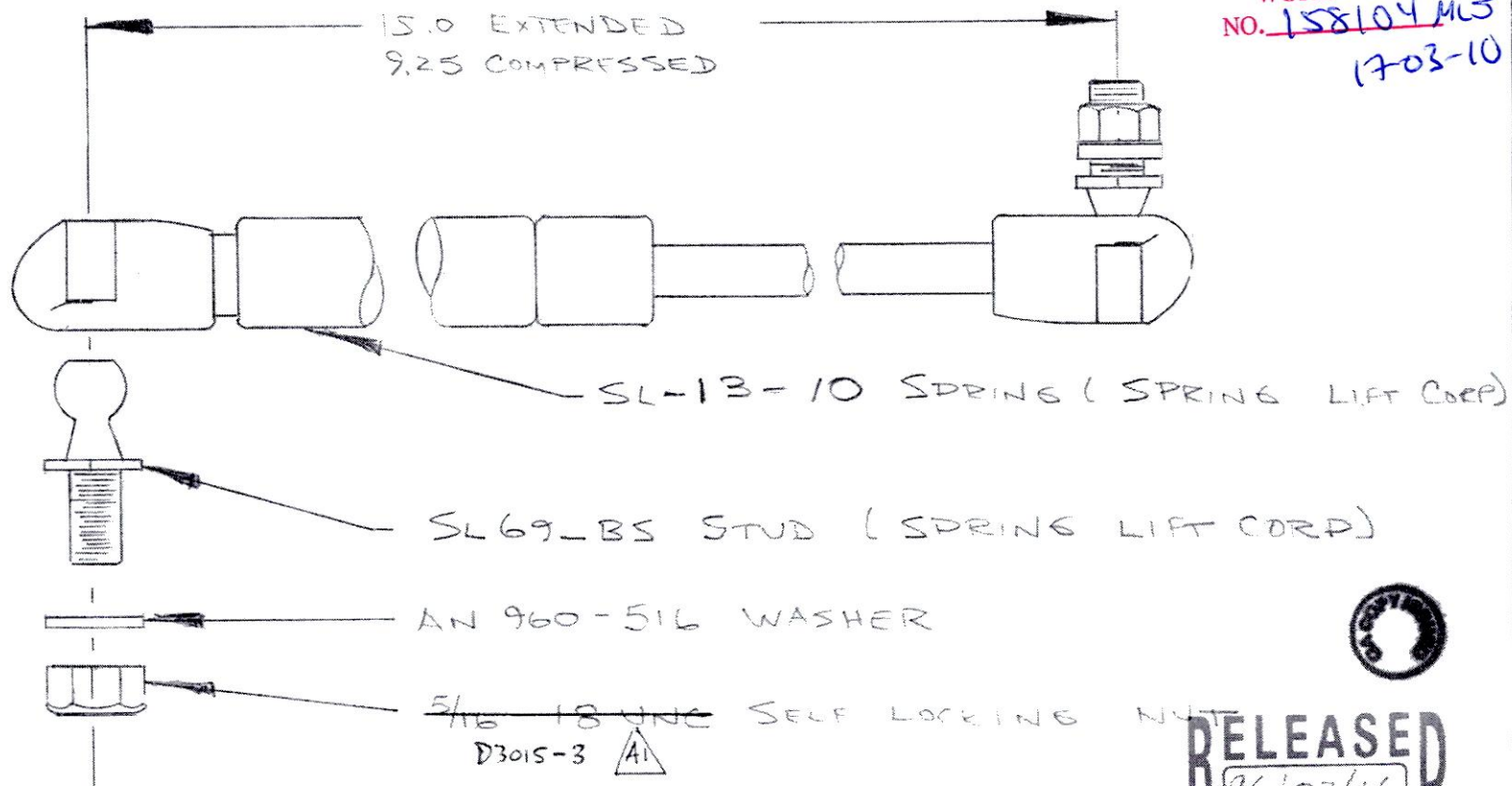
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158104 ML5
1703-10



RELEASED
96/07/16

A1		REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO		ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
A1		DRAWN			BASIC CODE		CONTRACT NO.		DRAWN		DATE	
A1		APPROVED			D-DIMPLE D-DIMPLE OR SHEETS C-COUNTERSINK		HATTON		07/28/96		DART	
A1		DESCRIPTION OF CHANGE	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		BASIC CODES		DESIGN		STRESS		TITLE	
A1			GENERAL		B2-M520470AD B8-M520426AD		HATTON				GAS SPRING ASSEMBLY	
A1			LIMITS		BASIC CODES		CHECKED		DATE		CODE	
A1			1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 5 - 7742 5. HOLES PER AND 10387		1. TOLERANCES - .XX ± .030 2. ANGLES - .XX ± .010 3. PARALLELISM - .XX ± .0025 4. ECCENTRICITY - .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRAL LINES .005		HATTON		07/28/96		DZ153	
A1			REPORT ALL DISCREPANCIES - DO NOT SCALE				CLIENT				SCALE 1:1	

DZ153



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO35614

Purchase Order Date 3/16/2017 10:16:10 AM
PO Print Date 3/16/2017

Page Number 1 of 2

Order From :

VU-ATT001

Ship To : DART AEROSPACE LTD

ATTWOOD
25349 NETWORK PLACE
CHICAGO, IL 60673-1253
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAIL

MAR 16 2017

Contact Name

Vendor Phone 616-897-2285

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency USD

FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2153P AS PER DWG D2153 REV. A B158104 ATTWOOD P/N: SL13-10 (10LB)	Door Prop	3/23/2017 Yes 3/23/2017		36.00 Each	\$13.05	\$469.80
						Line Total:	\$469.80
3	71401-45 Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A025 certification of conformance A040 notification of quality escape A043 retention of quality documents	PROCUREMENT QUALITY CLAUSES	3/23/2017 No 3/23/2017		1.00	\$0.00	\$0.00
						Line Total:	\$0.00

SP17-4-5

Note:

3/16/2017



MotorGuide COLLECT
NEVER STOP.

151793240

BILL TO: DART AERO LTD.
REQ: 04/06/17

PRO NO: 00060
SHIP VIA: FEDEX GROUND
BDL: 00226970005932292

FREIGHT: _____

F ATTWOOD CORP
R
O 1016 NORTH MONROE
M LOWELL

MI 49331-0260

INCOTERMS: EXW SHIPPER DOCK

DART AERO LTD.
T 1270 ABERDEEN STREET
O

HAWKESBURY ON K6A 1K7

CRTS: 1 PO#: P035614

WGT: 12 DATE: 03/31/17

SPUR: 9

LABEL NO:

--ROUTING GUIDE INFO --

--SHIPPED--

CRTS	QTY	LOCATN	UM	PART# / UPC	DESCRIPTION / SKU	LN	QTY	WGT
1	36	✓	W03911	EA	SL13-10-1 ✓	GS SPRNG 15" EXTC 10# BL	1	✓ 36 12

SP17-45

DAS
38
9-88

===== COMPLETE =====

PICK BY: _____

PAGE: 1 (ONLY PAGE)

Commercial Invoice

ECI

Ship Date: 4/3/2017

International Tracking# : 584946075917

Purpose:

aACI-¥ZQN'[1α~

Nbr Pkgs: 1 BOX

ACI-584946075917

Shipper

ATTWOOD CORPORATION

Kevin Dyer

1016 N. MONROE

LOWELL

MI 49331 US 616 897-9241

IRS/EIN:

Food Shipment: N PN/EN:

Consignee

DART AERO LTD.

1270 ABERDEEN STREET

HAWKESBURY

ON K6A1K7

CA 6136325200

IRS/EIN:

Broker

FedEx Ground's Broker

Importer

IRS/EIN:

IRS/EIN:

MARKS/NBRS: ECCN: EAR99

HS CODE: 8302496035

CTRY MFG: MX

WEIGHT: 0.0

UNIT QTY: 36 EA

UNIT VALUE: 13.050000

COMMODITY 469.80 USD

LICENSE:

EX DATE:

DESCRIPTION: GAS SPRING 15 EXTC 10 BL SCKT

Tracking Numbers

584946075917

TOTAL SHIPMENT WEIGHT:

12 LBS

TOTAL COMMODITY VALUE:

469.80

These commodities, technology, or software were exported from the
United States in accordance with the Export Administration regulations
Diversion contrary to United States is prohibited.

FREIGHT AMOUNT: 0.00

INSURANCE AMOUNT 0.00

OTHER AMOUNT: 0.00

TOTAL INVOICE: 469.80

TERMS OF SALE: DDU

NAME

TITLE

COMPANY

TELEPHONE :

SIGNATURE :

COMMENTS

:

FAX :

DATE :

Carrier Code: FDEG

INTERNATIONAL
SHIPMENT NUMBER

328825271

FedEx Ground OP-089 8/13

I declare all information in this invoice to be true and correct.

Kevin Dyer

ATTWOOD CORPORATION

4/3/2017

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38
9-88

Date : 4/3/2017

Page Number : 1